

Work Order ID 150725

Tuesday, August 30, 2016 8:07:25 AM

150725

~~PRELIMINARY ISSUE~~

Page 1

Item ID: D4060-9 Accept *N900040100* Setup Start *NS1*
 Revision ID: PRELIM Stop *NS2*
 Item Name: Aft Bearpaw Clamp
 Start Date: 8/31/2016 Start Qty: 4.00 *4* Cust Item ID:
 Required Date: 9/6/2016 Req'd Qty: 4.00 *4* Customer:
 Reference:

Approvals: Process Plan: RM Date: 16/08/30 Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D4060	<u>REV C</u>								
100		0.00							
100									
Waterjet	Memo	0.03							
FLOW CNC Waterjet	1-Cut as per Dwg Dwg Rev: <u>CU</u> Prog Rev: <u>CU</u> 2-Deburr if necessary								
110	QC2- Inspect parts off machine FAI/FAIB	0.00							
110									
QC	Memo	0.01							
Quality Control									
120	QC8- Inspect parts - second check	0.00							
120									
QC	Memo	0.01							
Quality Control									

P.T.O.

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☒ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging Supplier ☐ Engineering ☒ Quality ☐ Other ☐					
Date : <u>16-09-20</u>		Step #: <u>120</u>		QTY Effective : <u>1</u>			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								

Work Order ID 150725

Tuesday, August 30, 2016 8:07:25 AM

150725**PRELIMINARY ISSUE**
DAS
9
9-89

Page 2

Item ID: D4060-9 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: PRELIM Stop ***NS2***
Item Name: Aft Bearpaw Clamp
Start Date: 8/31/2016 Start Qty: 4.00 ***4*** Cust Item ID:
Required Date: 9/6/2016 Req'd Qty: 4.00 ***4*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 *130* Brake NC Brake NC	Form as per dwg Memo	0.00 0.06			DAS 30 9-89	(4)			SEP 14 2016
140 *140* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.01				(4)			DAS 38 9-89 SEP 14 2016
150 *150* Packaging Packaging	Identify as per dwg & Stock Location: PRELIM 54 54 Memo	0.00 0.01				4			DAS 6 9-89 NOV 25 2016 DAS 38 9-89 SEP 14 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER : _____					

Work Order ID 150725

Tuesday, August 30, 2016 8:07:25 AM

150725**PRELIMINARY ISSUE**
DAS
9
9-89

Page 3

Item ID: D4060-9

Accept

N900040100

Setup Start

NS1

Revision ID: PRELIM

Stop

NS2

Item Name: Aft Bearpaw Clamp

Start Date: 8/31/2016 Start Qty: 4.00

4

Cust Item ID:

Required Date: 9/6/2016 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start

NR1

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

NR2Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

QC21- Final Inspection - Work Order Release

0.00

160

QC

Memo

0.07

DAS
21
9-89

NOV 2 5 2016

Quality Control

DAS
21
9-89

OCT 1 4 2016

POSITIVE RECALLEFFECTIVE DAS AUTH _____RELEASED 9 9-89DATE 10-11-25

ENG 7100

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____ Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐
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Date :	Step #:	QTY Effective :	MRB (QSI042) Approval
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Description Work Order Deviation	Disposition	Completed By
		Lead hand / Supervisor Approval Verification
		QC / QA Coordinator Approval

Root Cause			FAULT CATEGORY		
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐
Past Expiry Date ☐	Manufacturing Process ☐	OTHER :			
Misidentified ☐	Past Due ☐				

Picklist Print

Tuesday, August 30, 2016 8:07:25 AM

Page 1

Work Order ID: 150725

150725

Parent Item: D4060-9

D4060-9

Parent Item Name: Aft Bearpaw Clamp

Start Date: 8/31/2016

Required Date: 9/6/2016

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP REV:A 16.08.15 NEW ISSUE DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S14GA		Purchased	No				sf	28.6158		0.463158			

M304S14GA

304SS sheet .080

PR 2016/08/31

Location

Loc Qty

Loc Code

MAT019

16.8

M129972

5.7

M135061

11.1

TPI

11.815791

M134604

11.815791

0.7

DQA: _____ Date: _____



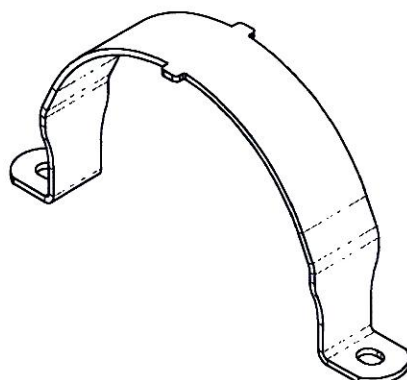
WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

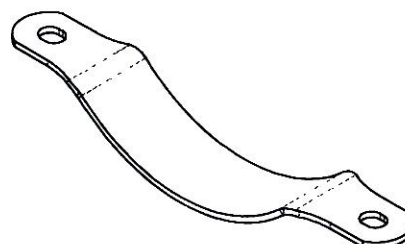
Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : _____					

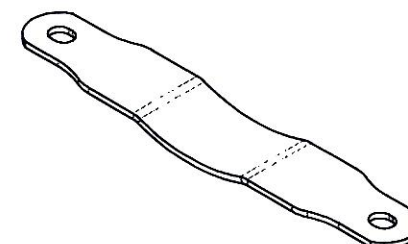
PRELIMINARY ISSUE



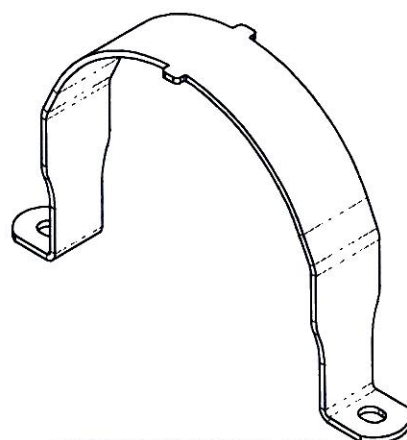
D4060-1 412 SKI CLAMP, TOP



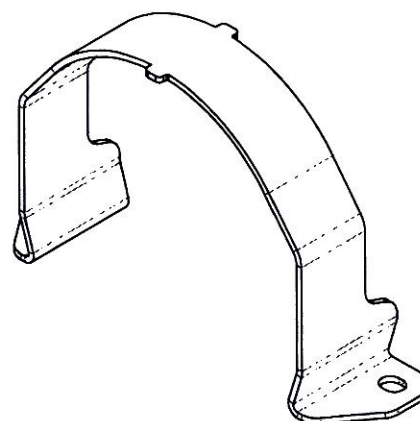
D4060-3 412 SKI CLAMP, BOTTOM



D4060-5 412 SKI CLAMP, AFT



D4060-7 BEARPAW CLAMP



D4060-9 AFT BEARPAW CLAMP

NOTES:

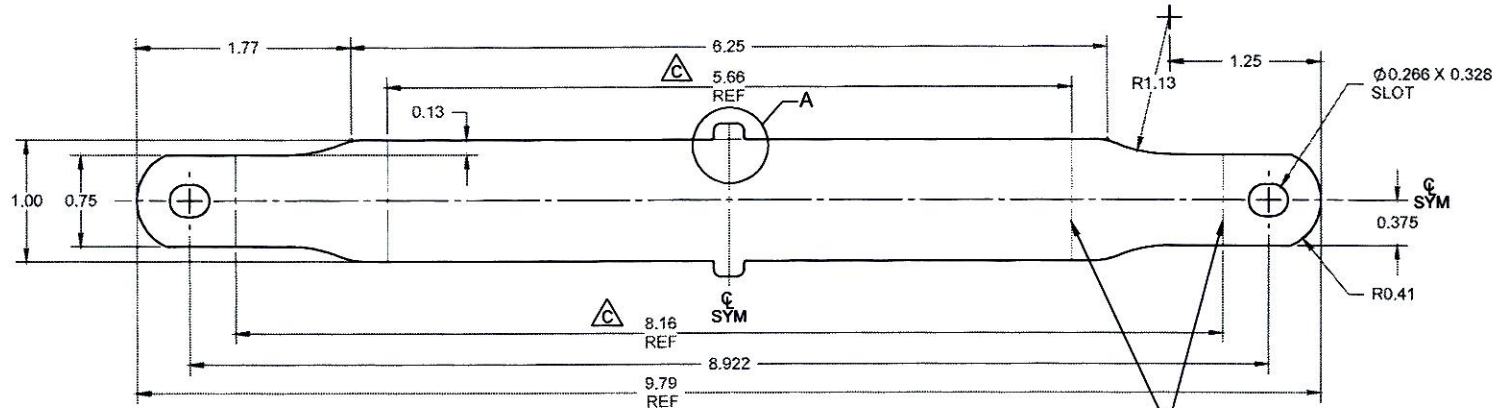
- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET ANNEALED 2B FINISH, 14 GAUGE (0.078 THICK)
PER AMS 5513 (304) OR 5524 (316) OR ASTM A240 OR ASME SA240
REF. DART SPEC. M304S14GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER DART QSI 044
- 7) WEIGHT: D4060-1/-7 = 0.23 lbs, D4060-3/-5 = 0.12 lbs, D4060-9 = 0.28

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

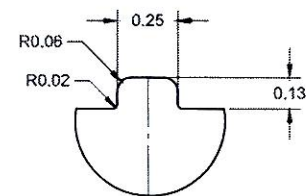
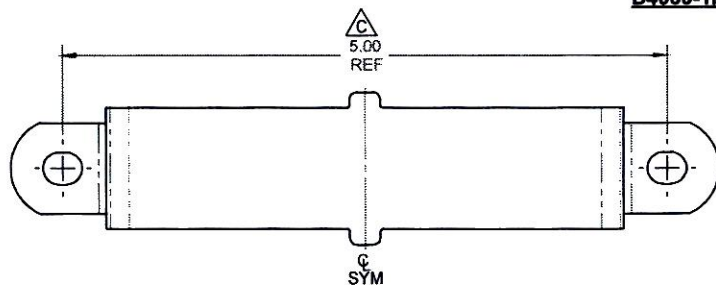
NO. 150725 *MLJ*
16-08-30

C	ADD -7 & -9. REASON: CIR16-67. ADD "REF" FOR BEND LINES.	AJS	16.05.09
B	ADD CUSHION RETENTION DETAILS TO -1 CLAMP. REASON: PAR 14-368, PAR 14-331, NCR 14-3521	VS	15.05.14
A	NEW ISSUE	MB	10.03.31
REV.	DESCRIPTION	BY	DATE
DESIGN	VS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED	ML	DRAWING NO.	REV. C11
MFG. APPR.	DD	D4060	SHEET 1 OF 6
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	412 SKI CLAMP	NTS
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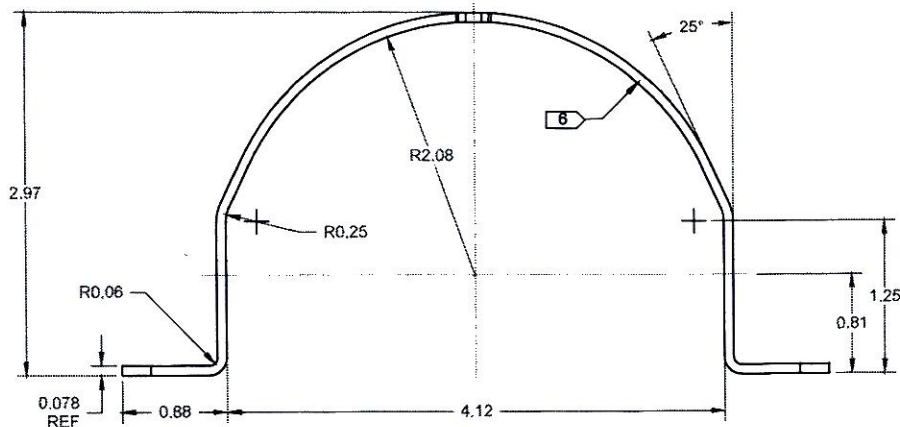
PRELIMINARY ISSUE



D4060-1F 412 SKI CLAMP. TOP
FLAT PATTERN



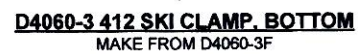
DETAIL A
SCALE 2X
2 PL



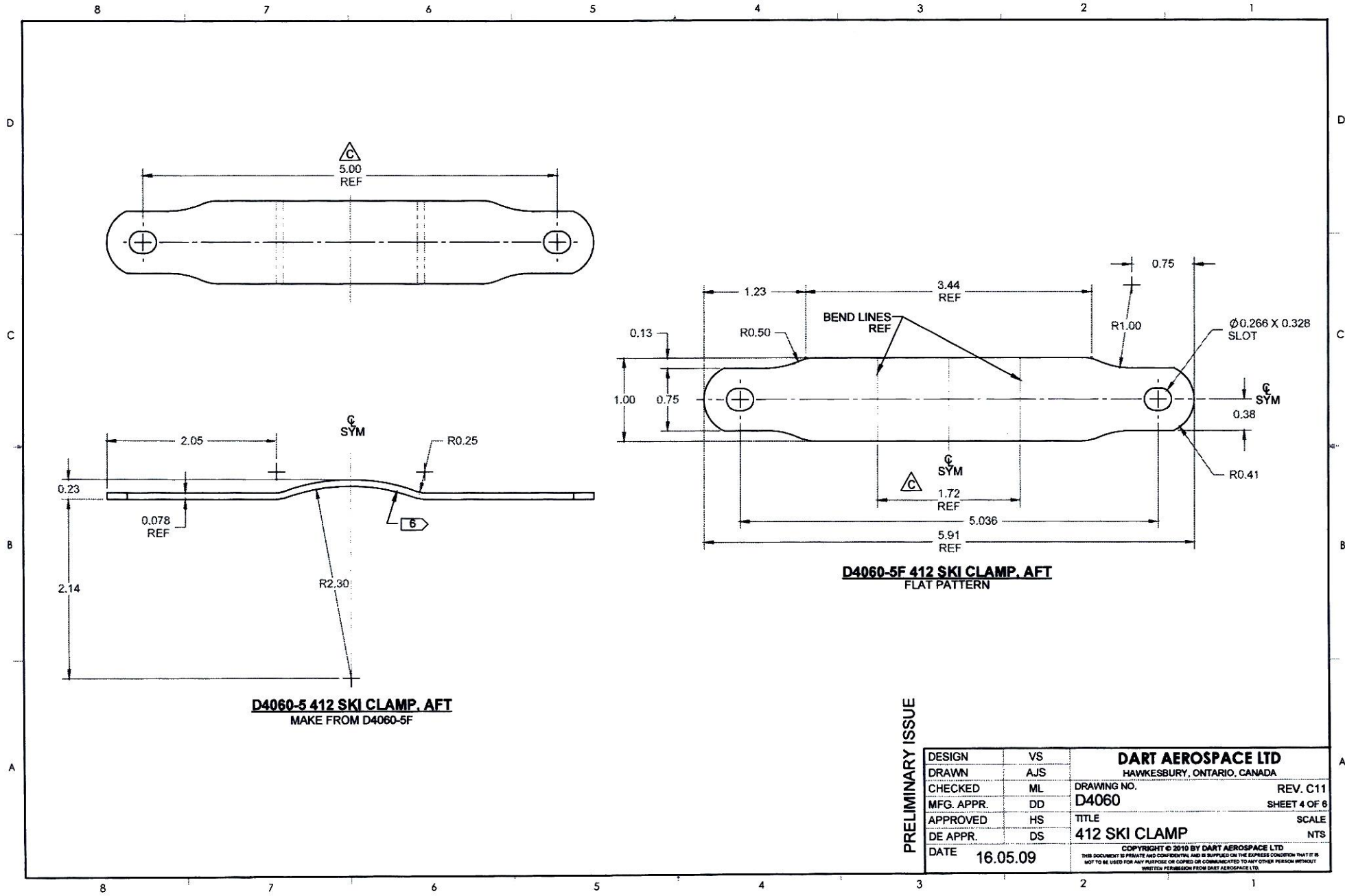
D4060-1 412 SKI CLAMP. TOP
MAKE FROM D4060-1F

PRELIMINARY ISSUE

DESIGN	VS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED	ML	DRAWING NO.	REV. C11
MFG. APPR.	DD	D4060	SHEET 2 OF 6
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	412 SKI CLAMP	NTS
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DESIGN	VS	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESSBURY, ONTARIO, CANADA	
CHECKED	ML	DRAWING NO.	REV. C11
MFG. APPR.	DD	D4060	SHEET 3 OF 6
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	412 SKI CLAMP	NTS
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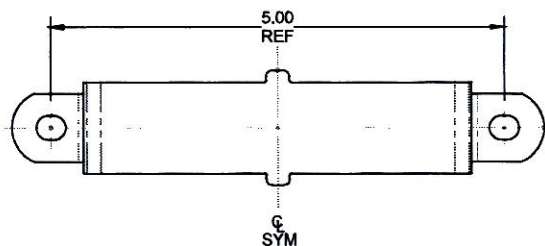
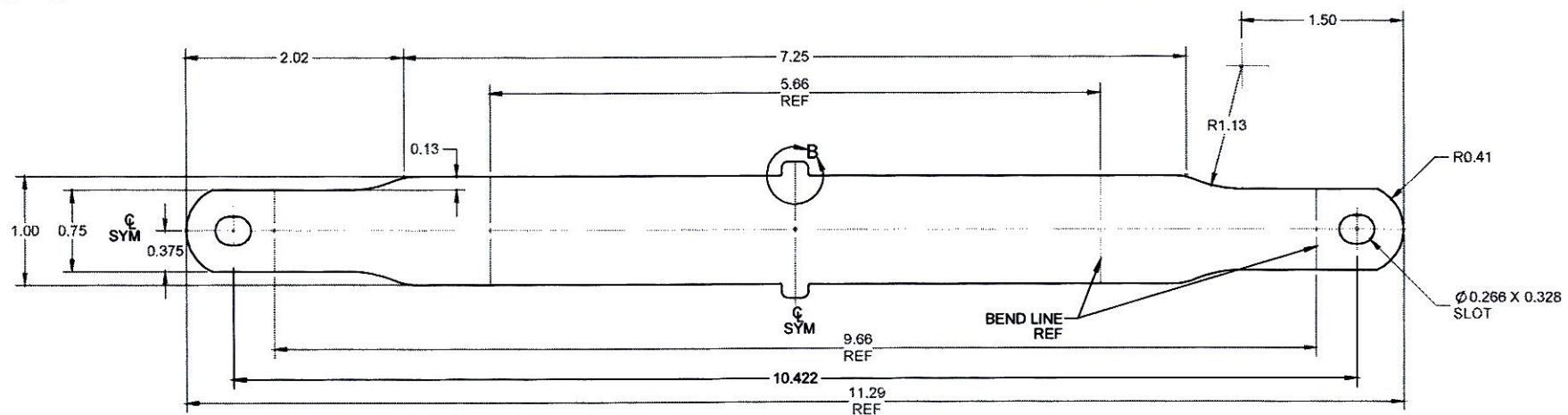


D4060-5 412 SKI CLAMP. AFT
MAKE FROM D4060-5F

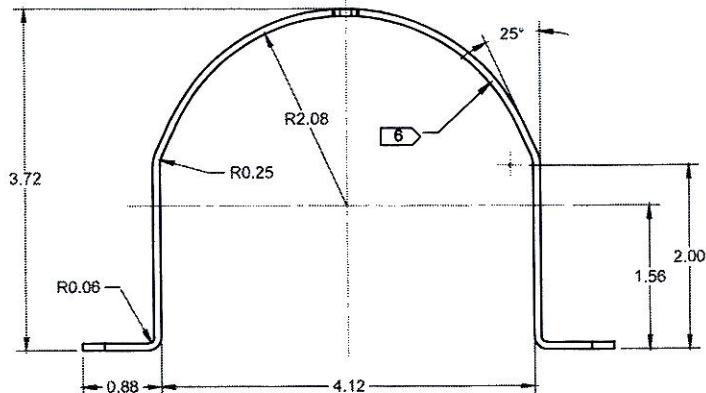
D4060-5F 412 SKI CLAMP. AFT
FLAT PATTERN

PRELIMINARY ISSUE

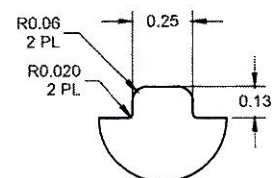
DESIGN	VS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED	ML	DRAWING NO.	REV. C11
MFG. APPR.	DD	D4060	SHEET 4 OF 6
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	412 SKI CLAMP	NTS
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D4060-7F BEARPAW CLAMP
FLAT PATTERN



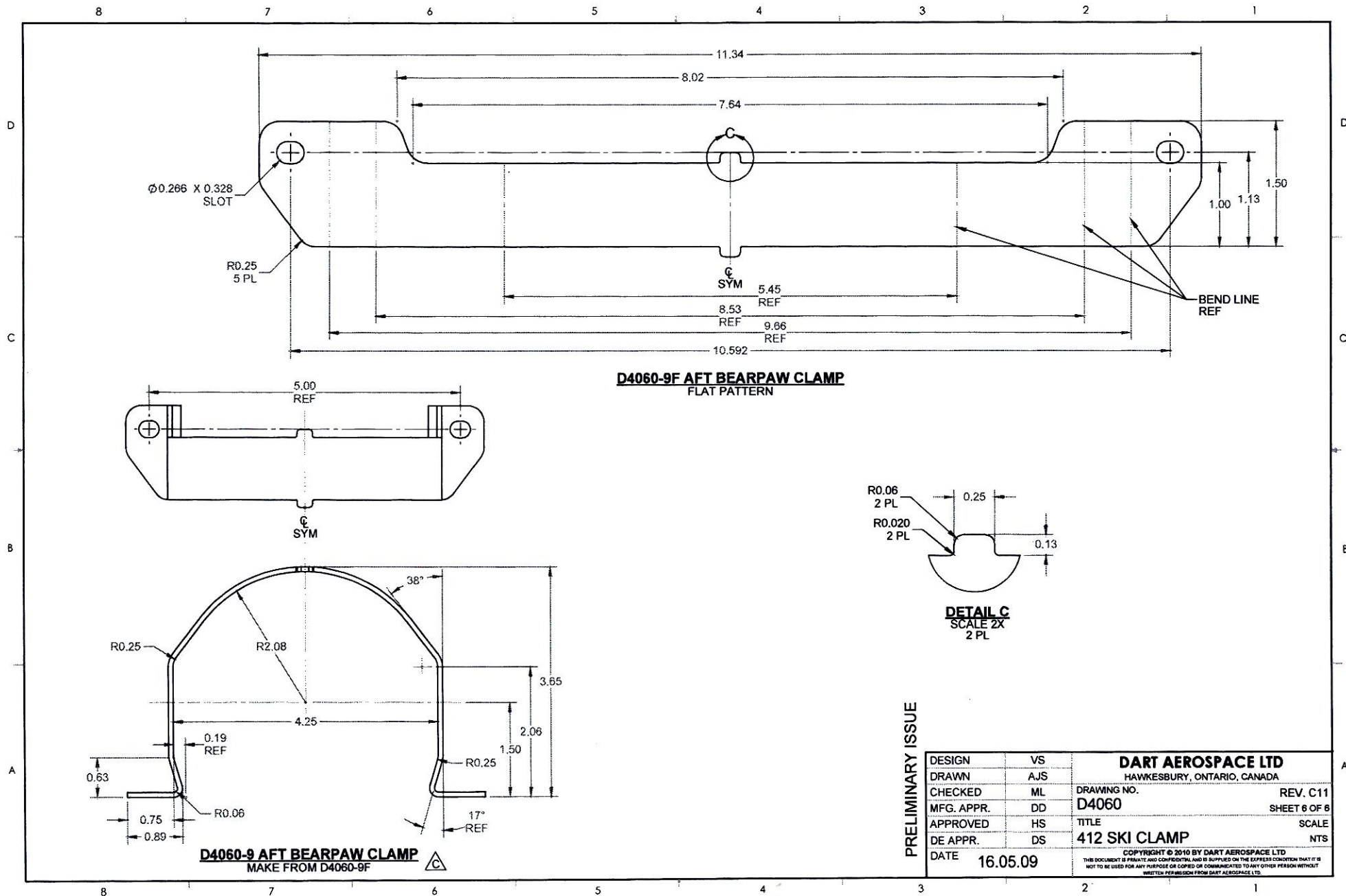
D4060-7 BEARPAW CLAMP
MAKE FROM D4060-7F



DETAIL B
SCALE 2X
2 PL

PRELIMINARY ISSUE

DESIGN	VS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED	ML	DRAWING NO.	REV. C11
MFG. APPR.	DD	D4060	SHEET 5 OF 6
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	412 SKI CLAMP	NTS
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Fax : 1 866 456-4242

EXPÉDIEZ À / SHIP TO :

DART AEROSPACE LTD
1270 ABERDEEN STREET
HAWKESBURY,
ONTARIO
K6A 1K7

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COMMANDE		
ORDER	N°	267190
DATE		28/06/16
BON DE LIVRAISON PACKING SLIP		N°
DATE DE LIVRAISON DELIVERY DATE		21/06/16

VOTRE N° DE COMMANDE / YOUR PO. N° PO32767		VEND./SALES M. U	CODE CLIENT / CUST. CODE DAER	EXPÉDIER PAR / SHIP VIA 12345	TERMES / TERMS NET 30 JOURS	TERR. 26	REMARQUES / REMARKS	PAGE N° 001
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[illegible]

POIDS TOTAL	
TOTAL WEIGHT	

* Unités de mesure	CLB	Cent (100) livres	CPI	Cent (100) pieds	UN	Unité	PI	Pieds	PC	Pied carré
Units of measure		Hundred pounds		Hundred feet		Unit		Feet		Square foot

CONCLUSIONS

LES MATERIAUX LIVRES ET FACTURES (TOUTES LES DEBITES DEMANDANT LA PRESENCE DE L'ACHETEUR ENAMINE), JUSQU'A PARFAIT PAIEMENT COMPLET INCLUSE. - LES PISCINES DE PERTE OU BIEN SONT A LA CHARGE DE L'ACHETEUR, - LE Fournisseur DE QUALITE GARANTIT JUSQU'A LA MEME DUREE QUE CELLE DU MATERIAU. - L'ACHETEUR S'ENGAGE A RESPECTER LES CONDITIONS SUIVANTES: JUSQU'A LA FIN DE LA PERIODE D'ACCEPTATION, ET TOUJOURS COMPTANT A L'AVANCE DANS LES 30 JOURS ENTRAINEES DES FRAIS DE 1% PAR MOIS TANT PAR ANNEE QUE AU COURS DE PAYER. - TOUT RETARD DE LA PART DE L'ACHETEUR AU DELA DES OBSERVATIONS EN VERTU DU PRESENT CONTRAT ENTRENE LA DECLARATION DU TERME ET PERMET AU VENDEUR, A SON CHOIX, DE REVENIR AU COURS DU SOLDE DU PRIX DE VENTE OU REFUSER LE BIEN VENDU. - TOUTE RECLAMATION DOIT ETRE FAITE DANS LES CINQ JOURS SUivant LA PRESENTATION DE CE DOCUMENT. - TOUTE MARCHANDISE ENDOMMAGEE, ALTEREE OU COUPEE NE PEUT ETRE REPRISE. - AINSI RETOUR DE MARCHANDISE NE SERA ACCUSE SANS NOTIFICATION. - TOUTE MARCHANDISE RETOURNEE EST SUEUITE A DES FRAIS DE MANUTENTION DE 25%.

CONDITIONS :

ALL SOLID AND DELIVERED MATERIALS REMAIN THE PROPERTY OF "ACORN CAMP INC." UNTIL PAYMENT IS MADE FULL, COMPLETE AND CASHED. - ALL SOLID MATERIALS ARE AT THE BUYERS RISK. - ALL MATERIALS BEAR THE SAME WARRANTY AS GIVEN BY THE MANUFACTURER. - THE BUYER HEREBY AGREES TO RESPECT THE FOLLOWING CONDITIONS: 10% 30 DAYS FROM BILLING DATE AND THE BUYER ACCEPTS TO PAY ADMINISTRATION CHARGES OF 2% PER MONTH OR 24% PER ANNUM ON ALL PAST DUE ACCOUNTS OVER 30 DAYS. - ANY DEFAULT IN RESPECT WITH THIS CONTRACT WILL LEAD TO PAYMENT BY ACCELERATION AND PERMITS TO THE SELLER, AT HIS CHOICE TO CLAIM FOR THE BALANCE DUE OR THE REPOSSESSION OF THE GOODS SOLD. - ANY CLAIM MUST BE MADE WITHIN FIVE DAYS WITH THIS DOCUMENT ENCLOSED. - ANY MERCHANTS DUE THAT HAS BEEN DAMAGED, CUT OR MODIFIED CANNOT BE RETURNED. - ALL GOODS RETURNED MUST BE WITH OUR AUTHORIZATION AND ARE SUBJECT TO A 25% RESIDUING CHARGE.

SOUS-TOTAL
SUB TOTAL

T.P.S.
G.S.T.

T.V.Q. / T.V.H.
G.S.T. / H.S.T.

TOTAL

PREPARE PAR/PREPARED BY VERIFIC PAR/VERIFIED BY

LIBRE PAR / DELIVERED BY	HEURE / TIME
--------------------------	--------------

MARCHANDISE RECUE EN BONNE CONDITION / MERCHANDISE RECEIVED IN GOOD CONDITION

A/Y	M/M	J/D
-----	-----	-----

X

Nº ENR. TPS / GST REG. Nº 822 435 970 RT 000; • Nº ENR. TVQ / GST REG. Nº 22 127 8280 TQ 001

SIGNATURE DU CLIENT / CUSTOMER'S SIGNATURE

DATE _____

SCRIPTO 1971



740 Imperial Road North

Certificate: 145644 1

Customer: 007035 510

Your Order: 774450

METALLURGICAL TEST REPORT

North American Stainless Canada Inc.
740 Imperial Road North
Guelph, ON N1K1Z3
Canada

Ship To:

Date: 2/22/2016 Page: 1

Steel: 304

Finish: 2B

Corrosion: ASTM A262/14 A; 180 Bend OK

NAS Order: PN 0060108 02

PRODUCT DESCRIPTION:

STAINLESS STEEL COIL, C.R. ANNEALED & PICKLED; UNS 30400
ASTM A240/15a, A480/14b, A666/15/ASME SA270/13, SA480/13, SA666/13
CHEM ONLY ON FOLLOWING ASTM: A276/13, A479/13a, A484/13a, A312/13
CHEM ONLY ON FOLLOWING ASME: SA312/13, SA479/13
AMS 5513J IMRK; MIL-5 5059D AMEND3 (X CROWN HEAS)
NACE MR0175/ISO 15156-3:2009 A, MR0103/07, Q3766D-A X MAG PERM
MIN. SOLUTION ANNEAL TEMP 1900F, WATER QUENCHED

REMARKS:

Mat'l is Free of Mercury Contamination. No weld repairs.
EN 10204:2004 3.1; RoHS 1 & 2 Compliant
Material is Free of Radioactive Contamination
Steel Making Process: EAF, AOD, & Cont. Casting
Product Mfg. by a Quality Mgt. Sys. in Conf. w/ISO 9001
*Melted & Manufactured in the USA; Mat'l is DPAAS Compliant
*Melted & Manufactured in the USA; Mat'l is DPAAS Compliant

DAS
48
Q.89

Product Id	Coil #	Skid # Thickness	Width	Weight	Length	Mark	Pieces	Commodity Code
04X7D8 A	04X7D8 A	.0725	48.0000	10,350 COIL		5	1	74266942

Lab Accreditation Bureau, ISO/IEC 17025, Certificate# E2323
CHEMICAL ANALYSIS CM(Country of Melt) ES(Spain) US(United States) ZA(South Africa) JP(Japan) Chemical Analysis per ASTM A751/08

SEAL	CM	C %	CR %	CU %	MN %	MO %	N %	NI %	P %	S %
X7D8	US	.0684	18.1330	.4215	1.7985	.3050	.0637	8.0970	.0310	.0310
SI %										
.3045										

MECHANICAL PROPERTIES

Product Id#	Coil #	UTS KSI	20C .2% YS KSI	20C ELONG %-2"	% Hard RH	Tail Hard	Grain No.
04X7D8 A	04X7D8 A	F T 104.35	55.04	45.44	91.00	36.00	9.00

NAS hereby certifies that the analysis on this certification is correct. Based upon the results and the accuracy of the test methods used, the material meets the specifications stated. These results relate only to the items tested and this report cannot be reproduced, except in its entirety, without the written approval of NAS.

Technical
Dept. Mgr.

KRIS MARK

2/22/2016

ACTER CAMP INC. P.O. - 69039 ET 69032 S.O. - 372289

PSS 48146

29032



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID PO32767

Purchase Order Date 6/20/2016

PO Print Date 6/20/2016

Page Number 2 of 6

Order From :

VC-CAM002

Ship To : DART AEROSPACE LTD

CAMPI STEEL
935 BOUL. DU HAVRE
VALLEYFIELD, QC J6S 5L1
CA

1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

Contact Name

Vendor Phone 800 667 4248

Ship To Contact

Ship To Phone

Ship Via: Yours ppl

Ship Acct:

Buyer

Chantal Lavoie

Customer POID

Customer Tax # 10127-2607

Terms Net 30

Currency CAD

FOB FCA (Free Carrier)

3	M303B1.000X1.000	303 BAR 1" X 1"	6/27/2016	12.00	\$19.30	\$231.65
			Yes	f		
			6/27/2016			

MATERIAL: AISI 303 SS BAR AS PER ASTM A582
NOTE: AISI 304/316 NOT ACCEPTABLE

Line Total: \$231.65

4	M304B0.500X2.500	304 BAR .500 x 2.50	6/28/2016	12.00	\$10.95	\$131.40
			Yes	f		
			6/28/2016			

MATERIAL: AISI 304/316 SS BAR OR AISI 304/316 SS
AS PER ASTM A276 OR ASTM A240

NOTE: AISI 303 NOT ACCEPTABLE

Line Total: \$131.40

5	M304S14GA	304SS sheet .080	6/22/2016	32.00	\$8.13	\$260.05
			Yes	sf		
			6/22/2016			

MATERIAL: AISI 304/316 SS SHEET
ANNEALED
SPECIFICATION: MIL-S-5059
OR AMS 5513 (304)
OR AMS 5524 (316)
OR ASTM A240
OR ASME SA240

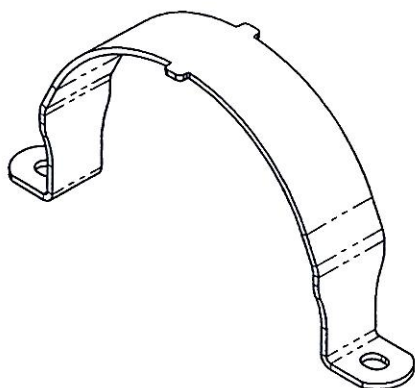
SP/6-6-22

PO Instructions: QUOTE # 386791,386554,386266,386708

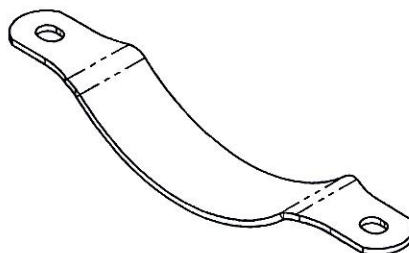
Note:

6/20/2016

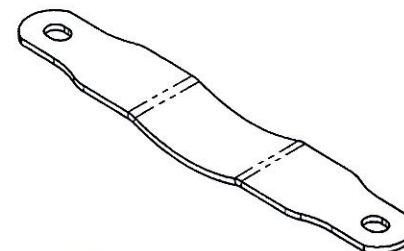
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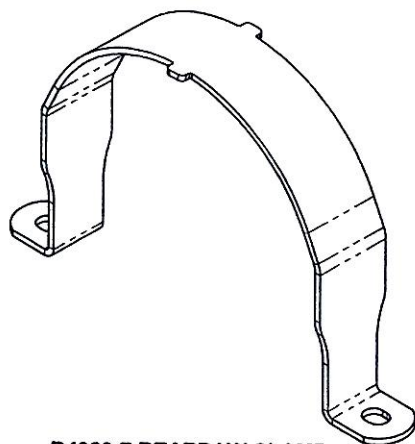
D4060-1 412 SKI CLAMP, TOP



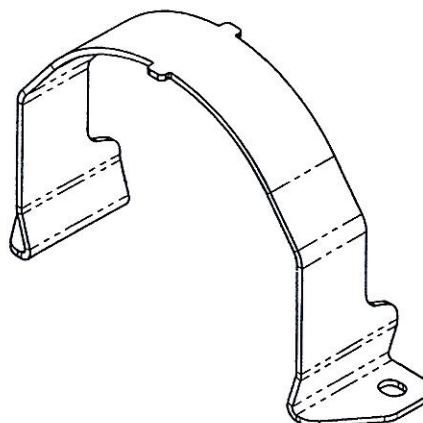
D4060-3 412 SKI CLAMP, BOTTOM



D4060-5 412 SKI CLAMP, AFT



D4060-7 BEARPAW CLAMP



D4060-9 AFT BEARPAW CLAMP

NOTES:

1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET ANNEALED 2B FINISH, 14 GAUGE (0.078 THICK)
PER AMS 5513 (304) OR 5524 (316) OR ASTM A240 OR ASME SA240
REF. DART SPEC. M304S14GA

2) FINISH: NONE

3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

4) UNITS: INCHES UNLESS OTHERWISE NOTED

5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX

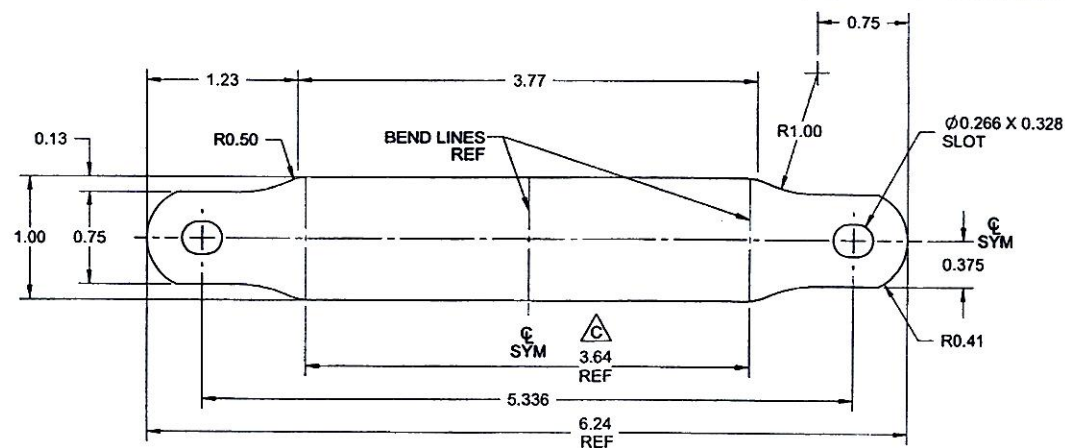
6) IDENTIFICATION: IDENTIFY PER DART QSI 044

7) WEIGHT: D4060-1/-7 = 0.23 lbs, D4060-3/-5 = 0.12 lbs, D4060-9 = 0.28

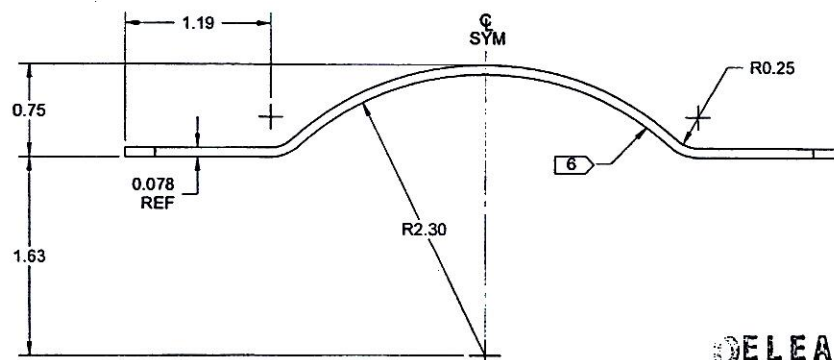
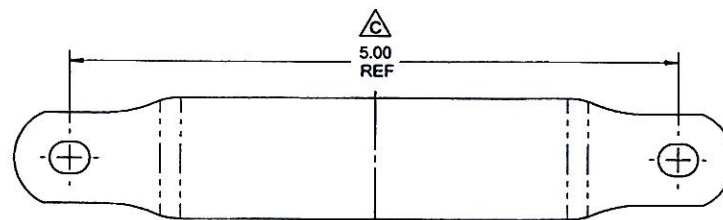
C	ADD -7 & -9 REASON; CIR16-67. ADD "REF" FOR BEND LINES.	AJS	16.05.09
B	ADD CUSHION RETENTION DETAILS TO -1 CLAMP. REASON: PAR 14-368, PAR 14-331, NCR 14-3521	VS	15.05.14
A	NEW ISSUE	MB	10.03.31
REV.	DESCRIPTION	BY	DATE
DESIGN	VS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED	ML	DRAWING NO.	REV. C
MFG. APPR.	DD	D4060	SHEET 1 OF 6
APPROVED	WM	TITLE	SCALE
DE APPR.	DS	412 SKI CLAMP	NTS
DATE	16.05.09	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	

RELEASED
2016-10-18
EN 16-154

APPROVED



D4060-3F 412 SKI CLAMP, BOTTOM
FLAT PATTERN

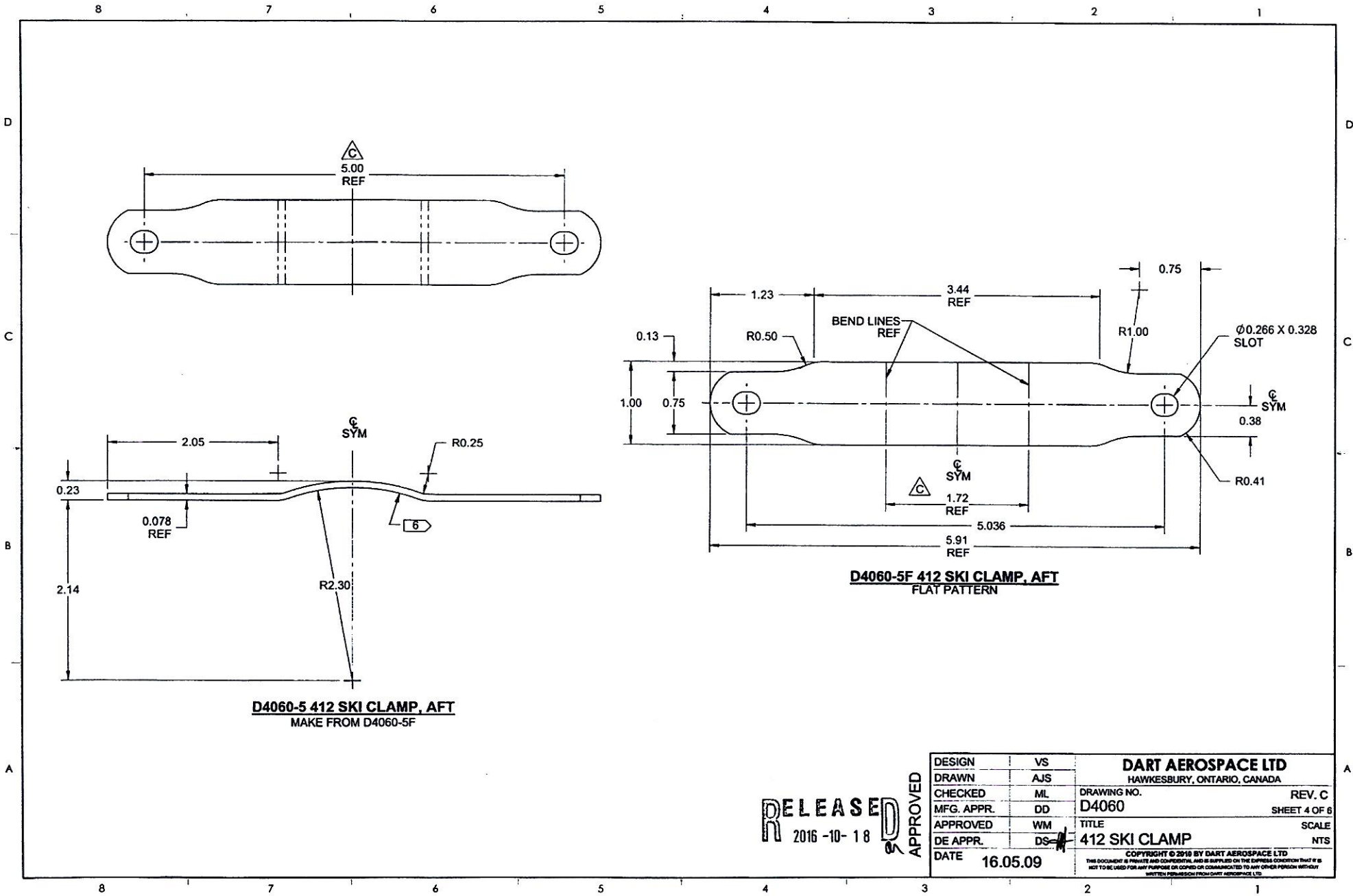


D4060-3 412 SKI CLAMP, BOTTOM
MAKE FROM D4060-3F

RELEASED
2016-10-18

APPROVED

DESIGN	VS	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	ML	DRAWING NO.	REV. C
MFG. APPR.	DD	D4060	SHEET 3 OF 8
APPROVED	WM	TITLE	SCALE
DE APPR.	DS	412 SKI CLAMP	NTS
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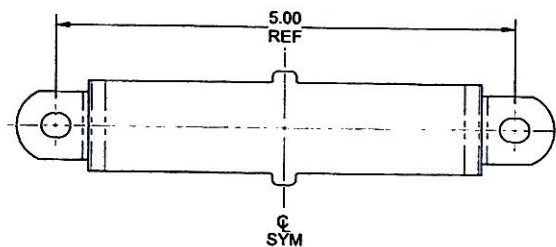
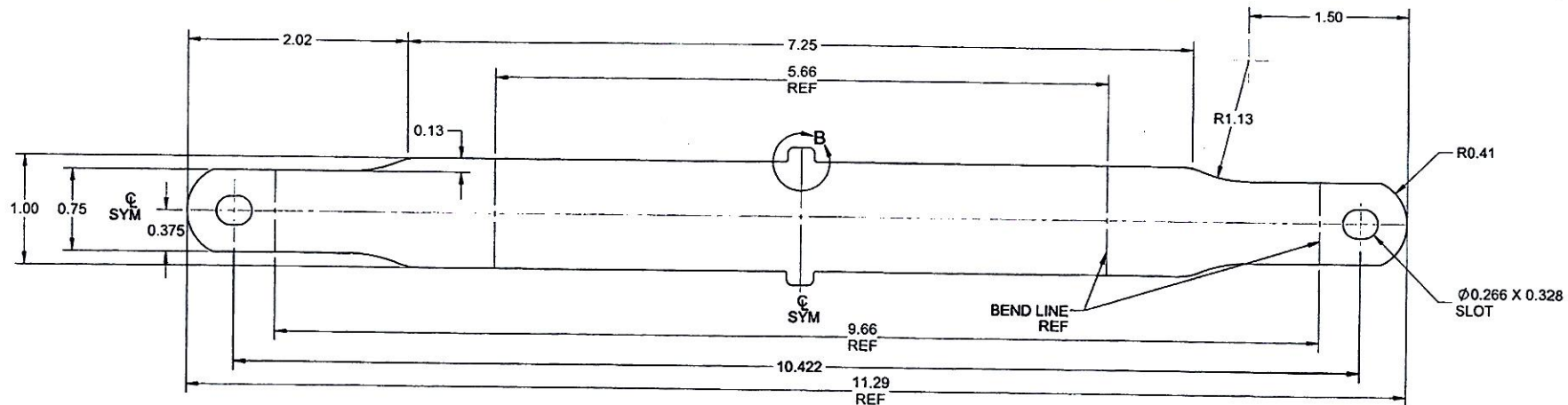


D4060-5F 412 SKI CLAMP, AFT
FLAT PATTERN

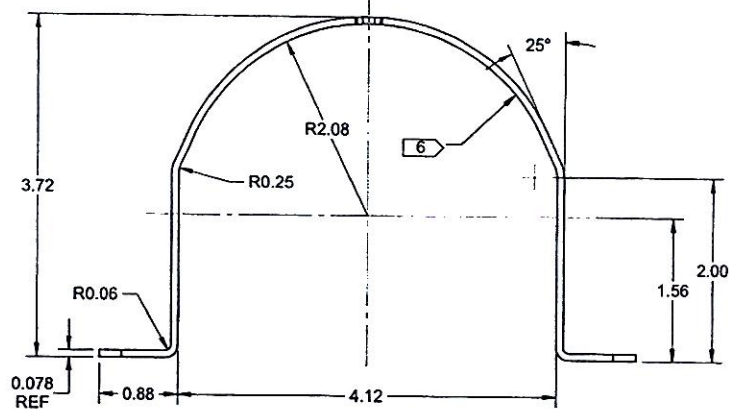
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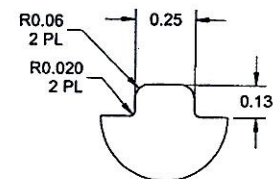
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DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	DL	DRAWING NO.	REV. C
MFG. APPR.	MD	D4060	SHEET 4 OF 4
APPROVED	WM	TITLE	SCALE
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D4060-7F BEARPAW CLAMP
FLAT PATTERN



D4060-7 BEARPAW CLAMP
MAKE FROM D4060-7F

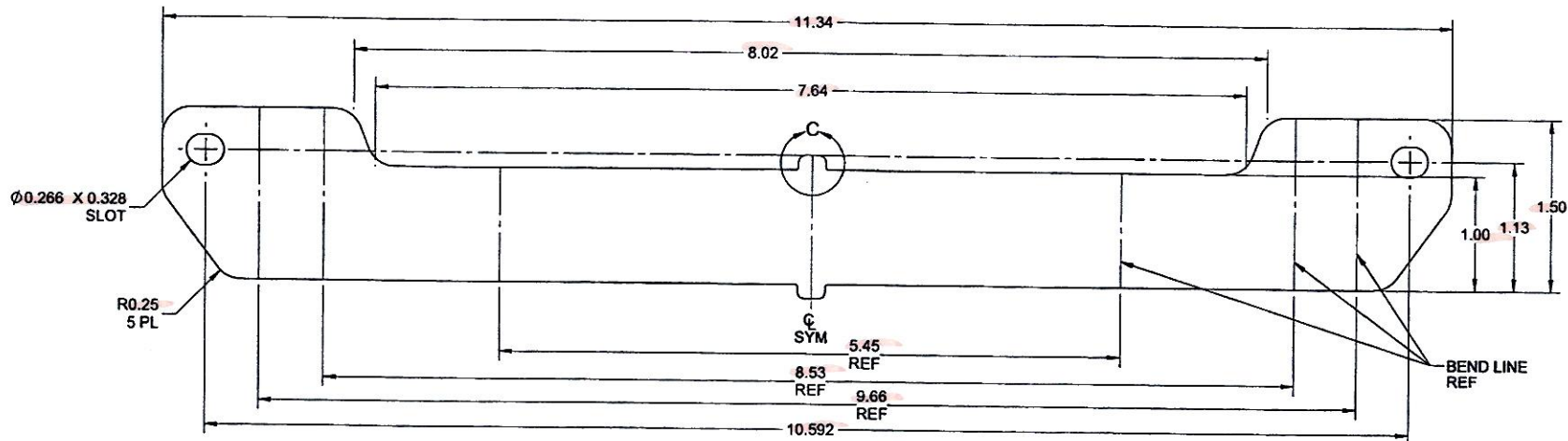


DETAIL B
SCALE 2X
2 PL

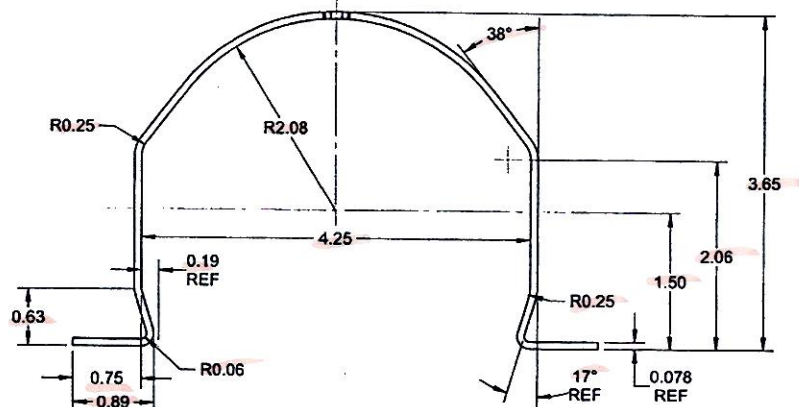
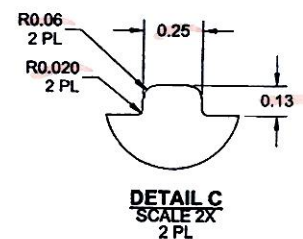
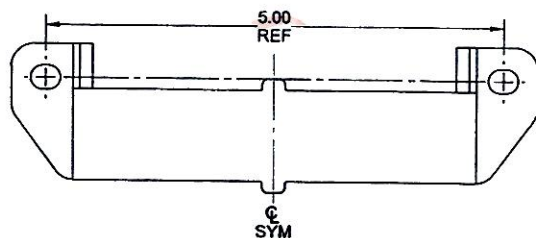
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CHECKED	ML	DRAWING NO.	REV. C
MFG. APPR.	DD	D4060	SHEET 5 OF 6
APPROVED	WM	TITLE	SCALE
DE APPR.	DS	412 SKI CLAMP	NTS
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D4060-9F AFT BEARPAW CLAMP 
FLAT PATTERN



D4060-9 AFT BEARPAW CLAMP 
MAKE FROM D4060-9F

RELEASE
2016-10-18

APPROVED

DESIGN	VS	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	ML	DRAWING NO.	REV. C
MFG. APPR.	DD	D4060	SHEET 6 OF 6
APPROVED	WM	TITLE	SCALE
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